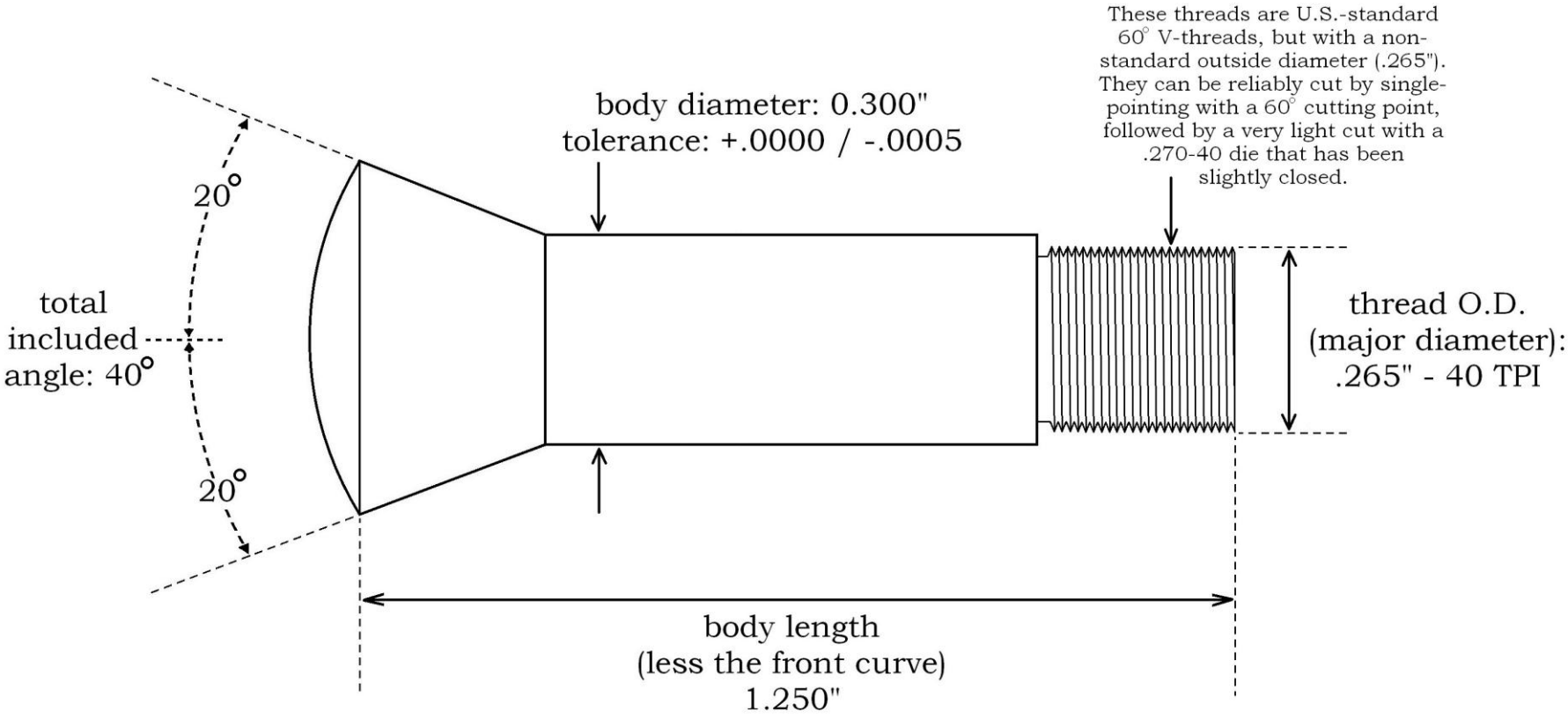
RIVETT 20S COLLETS


These threads are U.S.-standard 60° V-threads, but with a non-standard outside diameter (.265"). They can be reliably cut by single-pointing with a 60° cutting point, followed by a very light cut with a .270-40 die that has been slightly closed.
body diameter: 0.300"
tolerance: +.0000 / -.0005
20°
total included angle: 40°
20°
thread O.D. (major diameter): .265" - 40 TPI
body length (less the front curve) 1.250"

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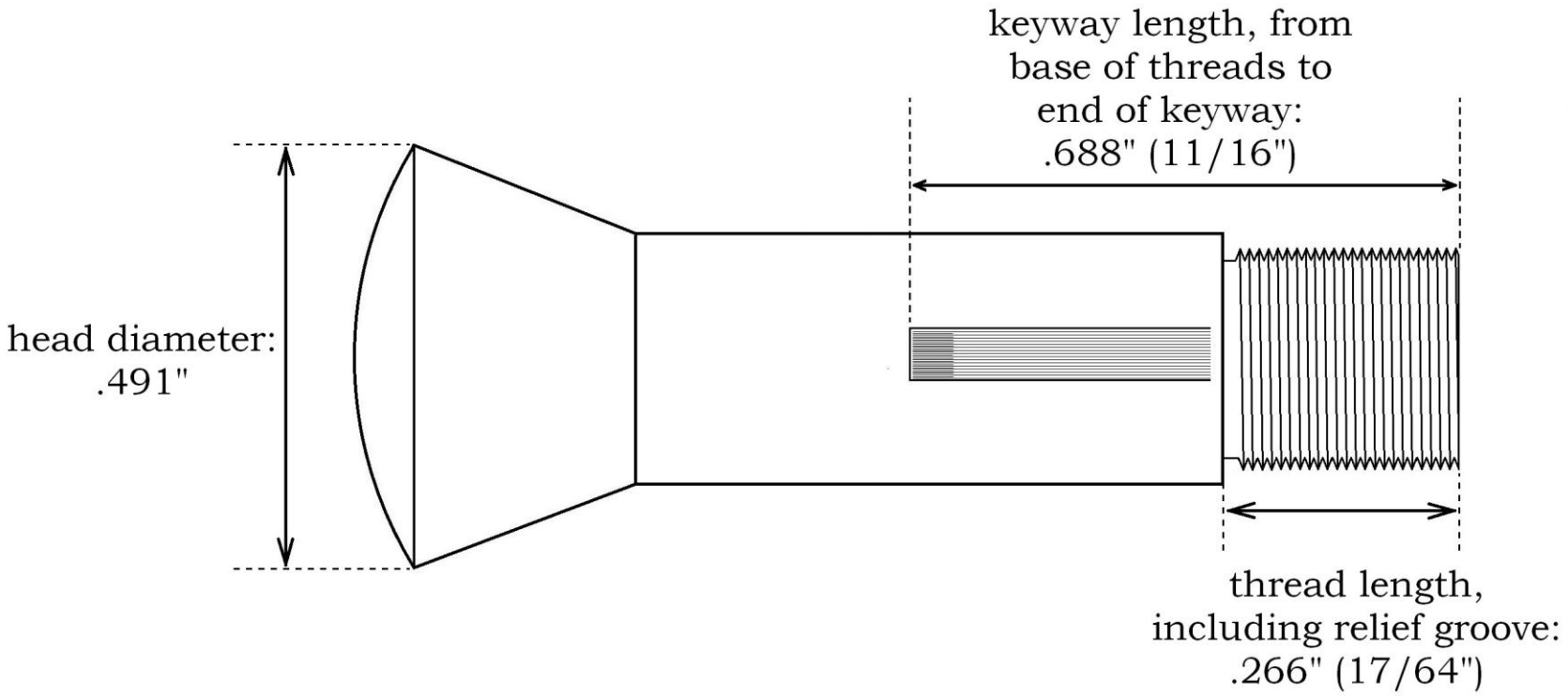

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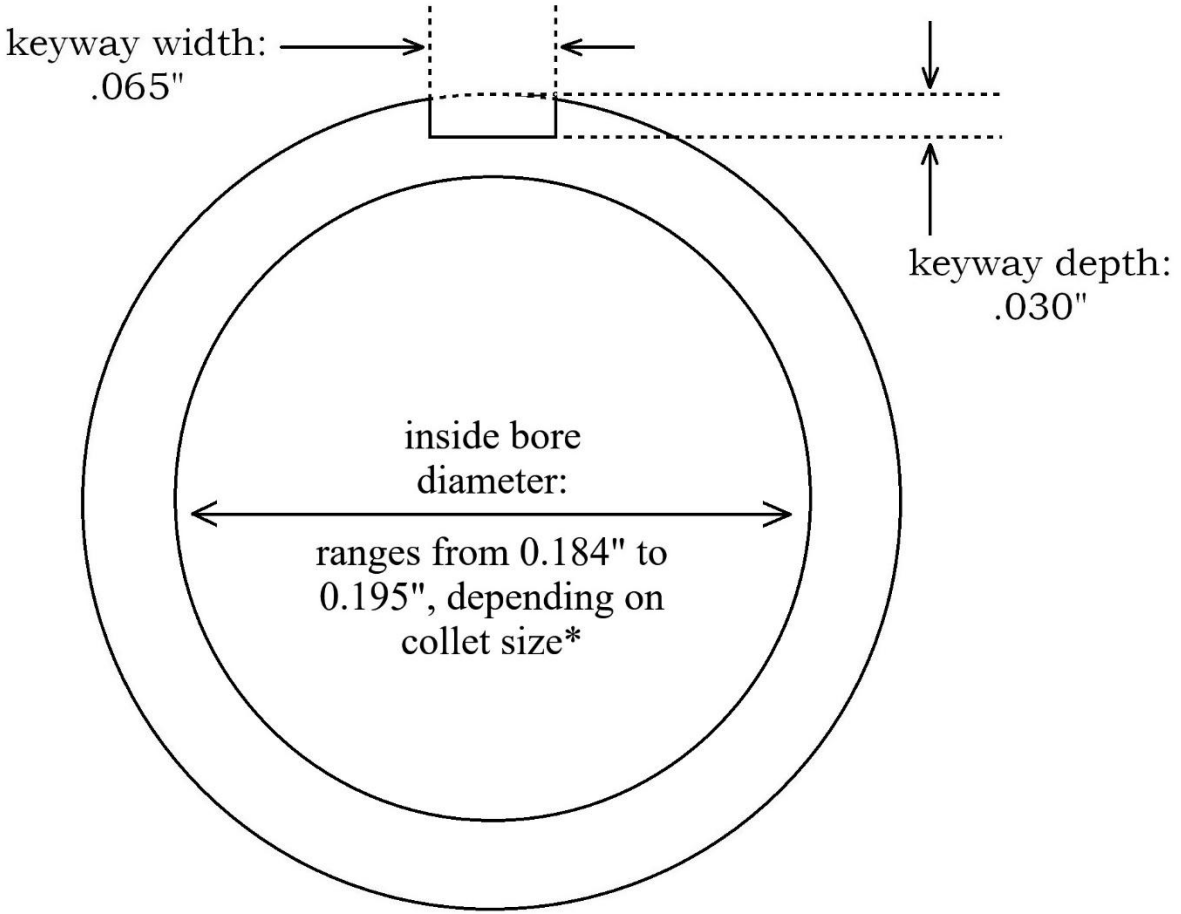

* About the inside bore diameters:

On May 13th 2026, I took two separate measurements from 9 different Rivett 2OS collets using a set of grade ZZ "minus" gage pins. First, I measured the inside diameter of the threaded end of each collet. I did this by selecting the largest gage pin that could fit. The bores are slightly tapered througout their length, so the gage pin that can just "slip fit" into the threaded end turns out to be just a little too large to be pushed all the way to the end. What stops the gage pin from going any further is an "internal step" just behind the front curve (which I call "the crown", but nobody else does).

The following table shows what size gage pin would enter the rear of the collet being measured, and what size gage pin is needed to fully reach the inside back of the front curve. I found some differences from collet to collet. The table to the right shows my findings. I hope you find them useful.

I have a full set of 80 different Rivett 2OS collets. I hope a sample set of 9 different sizes is representative of the whole set – but who knows. I may add measurements of other collets – if I do, I'll amend this document. For now, this is going to have to do.

COLLET #	REAR I.D.	TO REACH FRONT
#1	0.195"	0.190"
#9	0.191"	0.190"
#12	0.194"	0.194"
#23	0.193"	0.190"
#34	0.185"	0.175"
#45	0.185"	0.174"
#56	0.187"	0.177"
#67	0.192"	0.174"
#78	0.184"	0.170"